

Work Order ID 65370

January 13, 2011 1:06:24 PM

PRELIMINARY ISSUE

Page 1

Item ID: D206-667-207BL

Accept

Revision ID: PRELIM

Item Name: 206 Aft Crosstube

Start Date: 1/13/11 Start Qty: 1.00

Required Date: 1/20/11 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels as per PPP D206-667-207

0.00

110

0.00



CNC Bend 2

CNC Alpha 160 Bender

BENDING MACHINE - CROSSTUBES

Memo

Bend tube as per Dwg D206-667-247 using CNC bender program D206-667-207

0.00

120

0.00



QC

Quality Control

QC15- Crosstube Dimensional Check

Memo

0.00

11-01-24

11-1-14

11.01.17

Work Order ID 65370

January 13, 2011 1:06:25 PM

Page 2

Item ID: D206-667-207BL

Accept

Revision ID: PRELIM

Item Name: 206 Aft Crosstube

Start Date: 1/13/11 Start Qty: 1.00

Required Date: 1/20/11 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130



Crosstubes

Crosstubes

Crosstubes

Memo

0.00

1-Drill pilot holes in tube using drill Jig DT & DT and drill table DT8577 and tower holes #6 as per QSI0010 and as per Dwg D206-667-247. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT & DT as per Dwg D206-667-247 Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT & DT as per Dwg D206-667-247. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT & DT as per Dwg D206-667-247

6-Drill Fwd rivet holes using drill Jig DT as per Dwg D206-667-147. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT as per Dwg D206-667-247.

8-C'sink holes as per Dwg D206-667-247.

9 -Scribe part # and batch # using vibrating stylus as per Dwg D206-667-247 Inside of Cuff(Donot engrave on outside of tube)

10 -Deburr & Inspect for surface damage. Repair damage within limits as per

SAA

11-01-17

11-1-14

Work Order ID 65370

January 13, 2011 1:06:25 PM



Page 3

Item ID: D206-667-207BL

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: 206 Aft Crosstube

Start Date: 1/13/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/20/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Dwg
D206-667-247

140



HandFXtube

Crosstubes Chemical Conversion

0.00

Memo

0.00

Hand Finishing Crosstubes

SAD
11-01-17 ①

150



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

BE ① M/01/17

160



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

-inspector to pay
Dug only
Submitt ④

[REDACTED]

Page 4

Accept

Setup Start

Stop

Cust Item ID:[illegible]

Customer:

Reference:

Run Start

Stop

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

Outsource process - NDT per QSI038 4.1

0.00

[REDACTED]

Outsource2

Memo

0.00

Outsource process - NDT

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 13298

LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

180

0.00

Packaging

Packaging

Memo

0.00

Packaging

Ensure copy of NDT results attached to work order.

190

QC5- Inspect part completeness to step on W/O

0.00

[REDACTED]

QC

Memo

0.00

Quality Control

Ensure results are as per Dwg D206-667-247

CG 11/01/17 (1)

Lu/02/18 ①

mt 11 01 18 (17)

Work Order ID 65370

January 13, 2011 1:06:33 PM

Page 5

Item ID: D206-667-207BL

Accept

Revision ID: PRELIM

Item Name: 206 Aft Crosstube

Start Date: 1/13/11 Start Qty: 1.00

Required Date: 1/20/11 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200



SprayPaint

Spray Painting

SprayPaint

Memo

1-Prime inside and outside crosstube as per QSI 005 4.2
2-Paint outside crosstube with White Intron as per QSI 005 4.2

PRIME:

Start Time: _____

Finish Time: _____

PAINT:

Start Time: _____

Finish Time: _____

Primer: 115967

Paint: 115509

Clear: 115949

210



QC

Quality Control

QC14- Inspect Spray Paint

Memo

Wrap in plastic bag to protect from scratches

11-01-19

Work Order ID 65370

January 13, 2011 1:06:33 PM



Page 6

Item ID: D206-667-207BL

Accept



Setup Start



Revision ID: PRELIM

Item Name: 206 Aft Crosstube

Stop



Start Date: 1/13/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/20/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
	Crosstubes								
Crosstubes	Memo	0.00							
Crosstubes	1-Install nut plates as per Dwg D206-667-247.								
230		0.00							
	Skidtubes								
Crosstubes	Memo	0.00							
Crosstubes	1-Install support using 0.03" to 0.06" thick layer of magnobond 6398 per QSI 015. Let cure for 12h after installation and prior to packaging. Note: (3) top holes should be facing up. A/R Magnobond 6398 : <u>115580 exp: 07/2011</u>								
	2-Install supports and clamps as per Dwg D206-667-247. <u>Torque clamps to 80-100 in lb</u> <u>ml 11/01/21</u>								

Work Order ID 65370

January 13, 2011 1:06:39 PM

Page 7

Item ID: D206-667-207BL

Accept

Revision ID: PRELIM

Item Name: 206 Aft Crosstube

Setup Start

Stop

Start Date: 1/13/11 Start Qty: 1.00

Required Date: 1/20/11 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00				0	0	11-01-20	
Quality Control									
250	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									

Not Required
11-01-20

Work Order ID 65370

January 13, 2011 1:06:39 PM



Page 8

Item ID: D206-667-207BL

Accept



Setup Start



Revision ID: PRELIM

Item Name: 206 Aft Crosstube

Stop



Start Date: 1/13/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/20/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-667-207								
	Location: <u>63</u>								
	PPP Rev: _____								
280	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/1/2011
11/01/24
MF
11-01-24

RD1373JAN

POSITIVE RECALL
EFFECTIVE 11/21/13 AUTH [Signature]
RELEASED _____ DATE _____

Picklist Print

January 13, 2011 1:06:22 PM

Page 1

Work Order ID: 65370

Parent Item: D206-667-207BL

Parent Item Name: 206 Aft Crosstube




Start Date: 1/13/11

Required Date: 1/20/11

Start Qty: 1.00

Required Qty: 1.00

Comments: RevA 11.01.13 New Issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN5-10A  Bolt		Purchased	No				Each	191.0000	10	10			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST337			191						
				115589			54						
				115700			137						
AN5-32A  Bolt		Purchased	No				Each	226.0000	4	4			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST340			226						
				114405			16						
				115016			50						
				115108			50						
				115589			60						
				115698			50						
AN5-34A  Bolt		Purchased	No				Each	64.0000	4	4			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST340			64						
				113149			2						
				113226			2						
				115835			20						
				116003			20						
				116191			20						

Picklist Print

January 13, 2011 1:06:22 PM

Page 2

Work Order ID: 65370

Parent Item: D206-667-207BL

Parent Item Name: 206 Aft Crosstube

Start Date: 1/13/11

Required Date: 1/20/11

Start Qty: 1.00

Required Qty: 1.00

AN960JD516 NAS1149D0563J Purchased No

Each 34.0000 18 18



Washer



114742 11/12/10

Location	Loc Qty	Loc Code
ST	34	
103694	18	
107534	12	
109287	4	

D206-667-247TRN Manufactured No

Each 0.0000 1 1



Crosstube Ass'y

D2873-043 Manufactured No

Each 20.0000 2 2



Nut Plate Assembly



11-1-14
11-01-09

Location	Loc Qty	Loc Code
LG	18	
63497	18	
ST	2	
60981	2	

D2873-045 Manufactured No

Each 20.0000 2 2



Nut Plate Assembly



11-01-19

Location	Loc Qty	Loc Code
LG	20	
60982	4	
63498	16	

January 13, 2011 1:06:23 PM

Shop Packet Print

Page 2

Picklist Print

January 13, 2011 1:06:23 PM

Page 3

Work Order ID: 65370

Parent Item: D206-667-207BL

Parent Item Name: 206 Aft Crosstube

Start Date: 1/13/11

Required Date: 1/20/11

Start Qty: 1.00

Required Qty: 1.00

D2892-1 Manufactured No

Each

36.0000

2

2



Support

Location

Loc Qty

Loc Code

LG

36

41986

4

42785

20

62592

12

D3595-063-450 Manufactured No

Each

65.3390

4

4



RUBBER CUSHION

Location

Loc Qty

Loc Code

LG

28.33897368

53775

5.97897368

58161

3.56

59580

0.12

61465

4.68

63960

14

ST415

37

64171

32

64300

5

MS20601-AD4W10 Purchased No

Each

120.0000

14

14



RIVET

Location

Loc Qty

Loc Code

LG051

120

114245

2

115405

2

115881

16

116186

100

January 13, 2011 1:06:23 PM

Shop Packet Print

Page 3

Picklist Print

January 13, 2011 1:06:24 PM

Page 4

Work Order ID: 65370

Parent Item: D206-667-207BL

Parent Item Name: 206 Aft Crosstube



Start Date: 1/13/11

Required Date: 1/20/11

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

Each

1,353.000

4

4



Nut



1/12/11

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

1327

115156

5

115594

500

116104

126

116105

496

116548

200

MS21920-22

Purchased

No

Each

68.0000

4

4



Clamp(per MIL-DTL-8783C)



11-01-19

Location

Loc Qty

Loc Code

LG

68

114077

18

116207

50

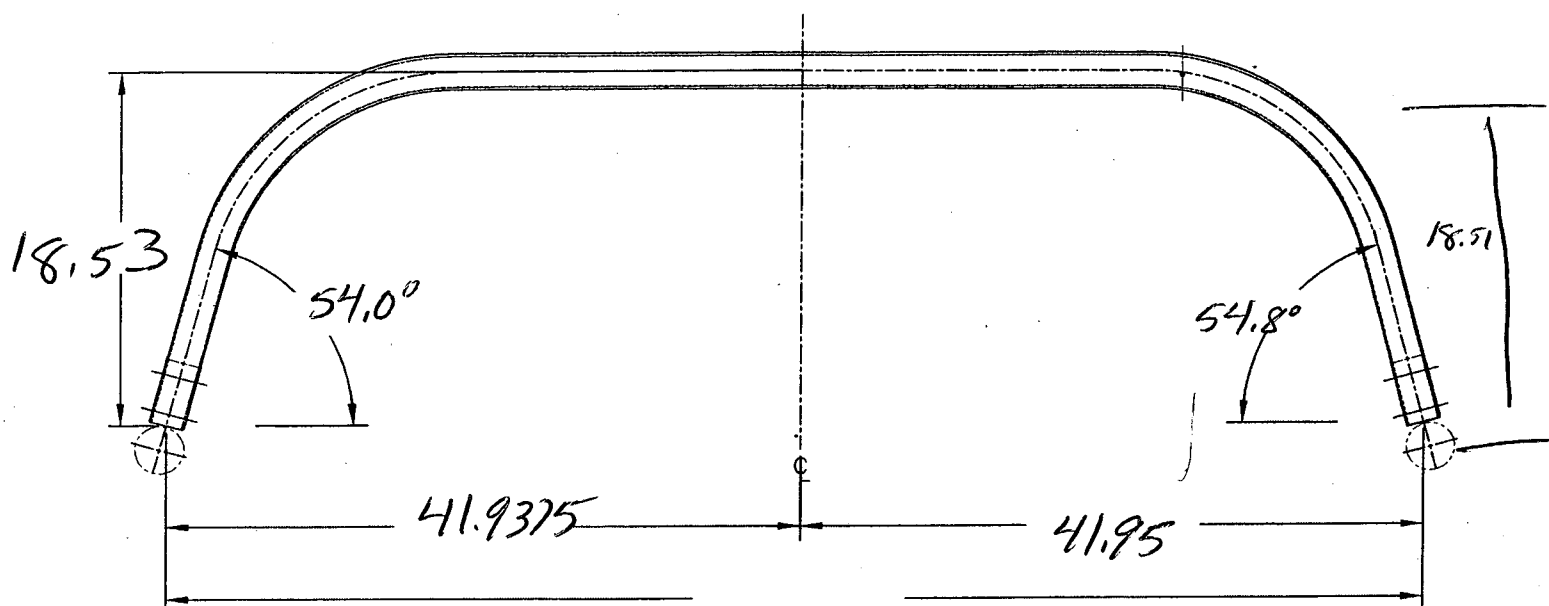
January 13, 2011 1:06:24 PM

Shop Packet Print

Page 4

DART AEROSPACE LTD		Work Order: 6.53 70
Description: Crosstube <i>Preliminary</i>		Part Number: D206-667-207
Inspection Dwg: D206-667-207	Rev: A	Page 1 of 1

Required Dimension	Min	Max
Height		
1/2 Span		
Angle		
Total Span		



Comments

QC15 Inspection	<i>JP</i>
Date	11-01-17

Rev	Date	Change	Revised by	Approved
		New Issue		

65370

Item	Qty -247	Part Number	Description
1	X	D206-667-247	CROSSTUBE ASSEMBLY (206L MID AFT)
2	1	D6004-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2892-1	SUPPORT
6	4	D3595-063-450	RUBBER CUSHION
7	4	MS21920-22	CLAMP
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 99.76±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-247" AND BATCH NUMBER ON
INSIDE OF CUFF PER DART QSI 044 6.4 (VIBRATING STYLUS).
- 7) WEIGHT: 21.1 lbs (-607 = 17.7 lbs)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO
BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI
015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE
D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE
LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

PRELIMINARY ISSUE

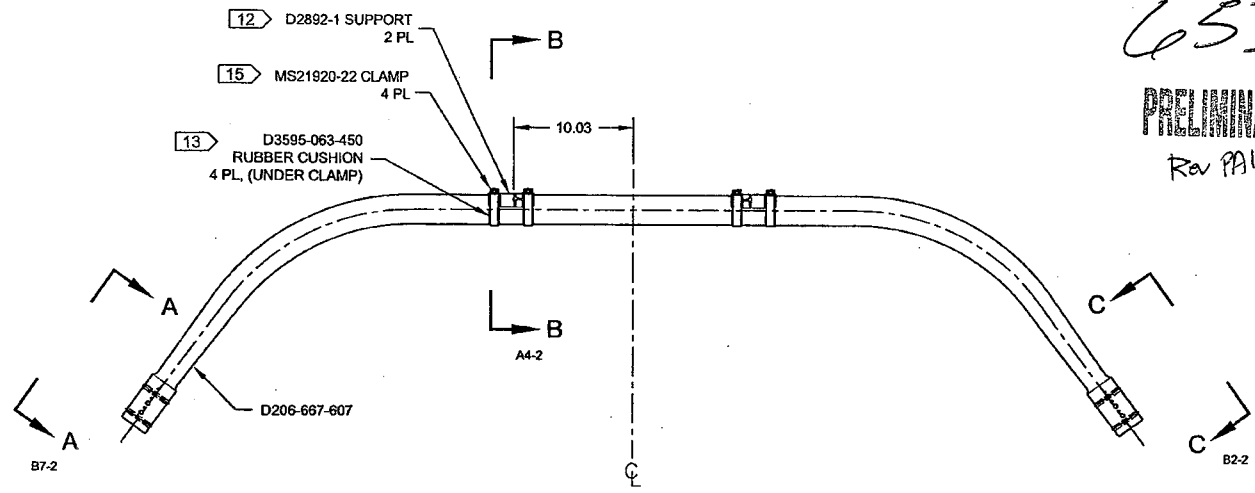
Rev PA1 9/11.01.06

REV.	NEW ISSUE	DESCRIPTION	CP	10.12.23
DESIGN	99	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	BY	DATE
DRAWN	99			
CHECKED	99	DRAWING NO.	REV.	9/11
MFG. APPR.		D206-667-247	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		CROSSTUBE ASS'Y (206L MID AFT)	NTS	
DATE	10.12.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

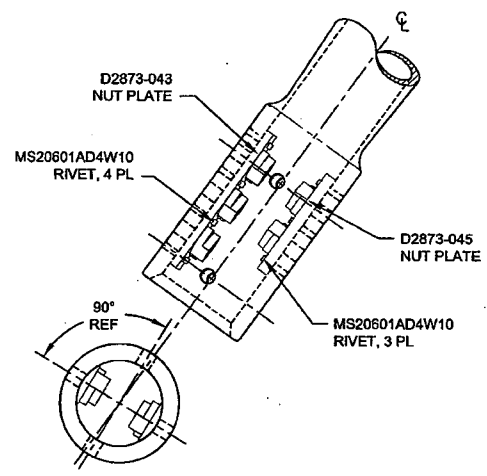
65370

PRELIMINARY ISSUE

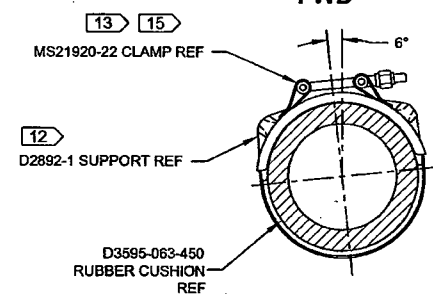
Rev PA1 11.01.06



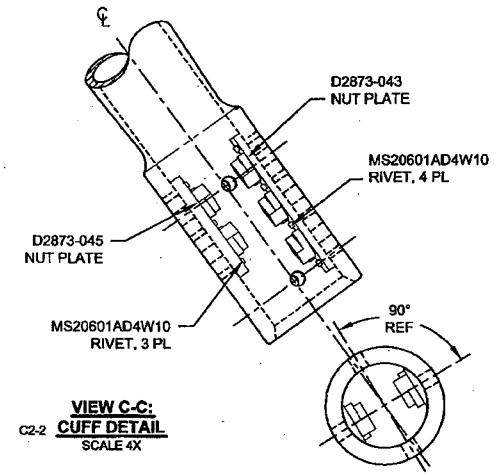
**D206-667-247
ASSEMBLY DETAIL
(VIEW LOOKING FWD)**



**VIEW A-A:
CUFF DETAIL
SCALE 4X**

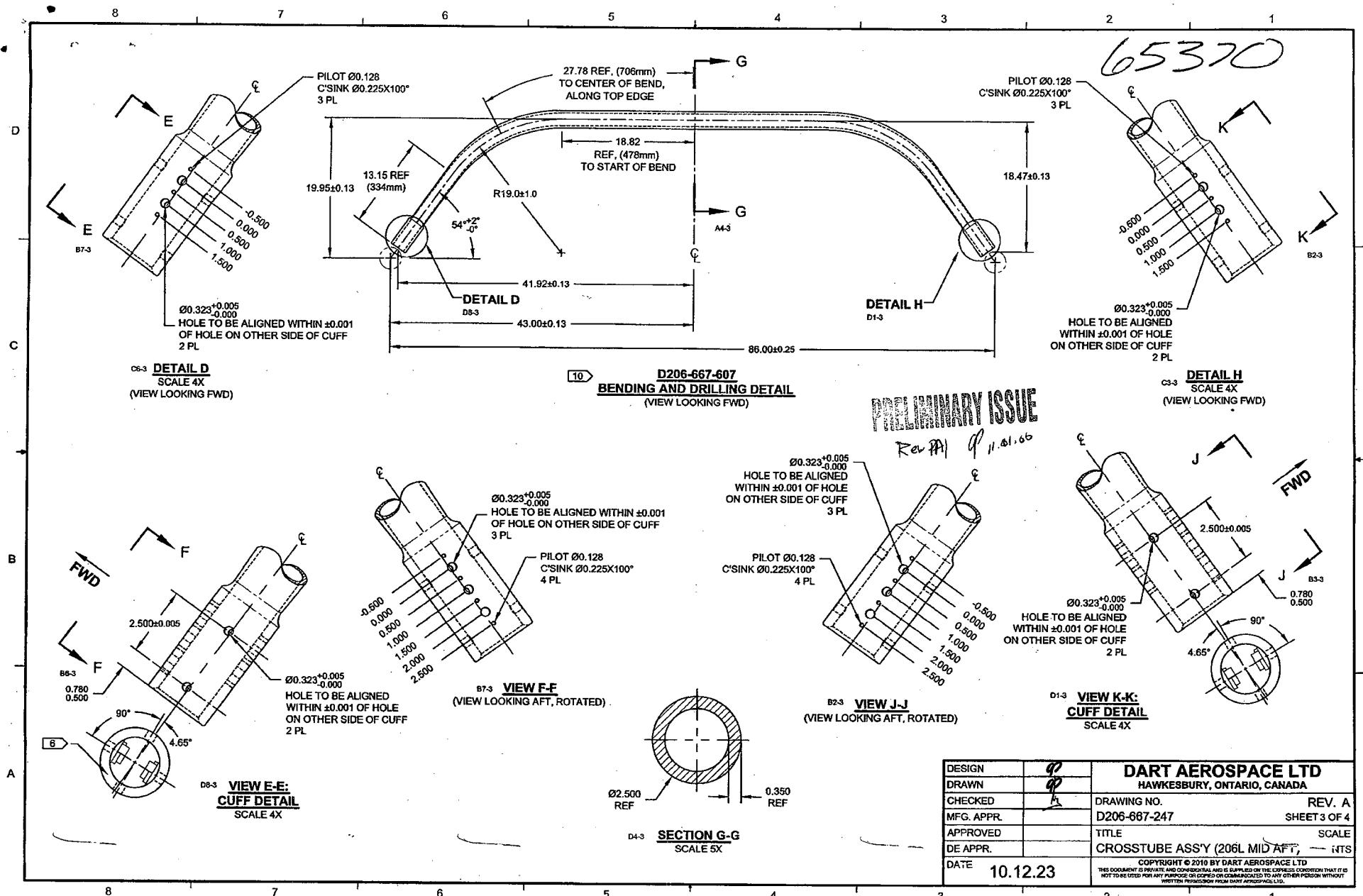


**SECTION B-B
SCALE 5X**

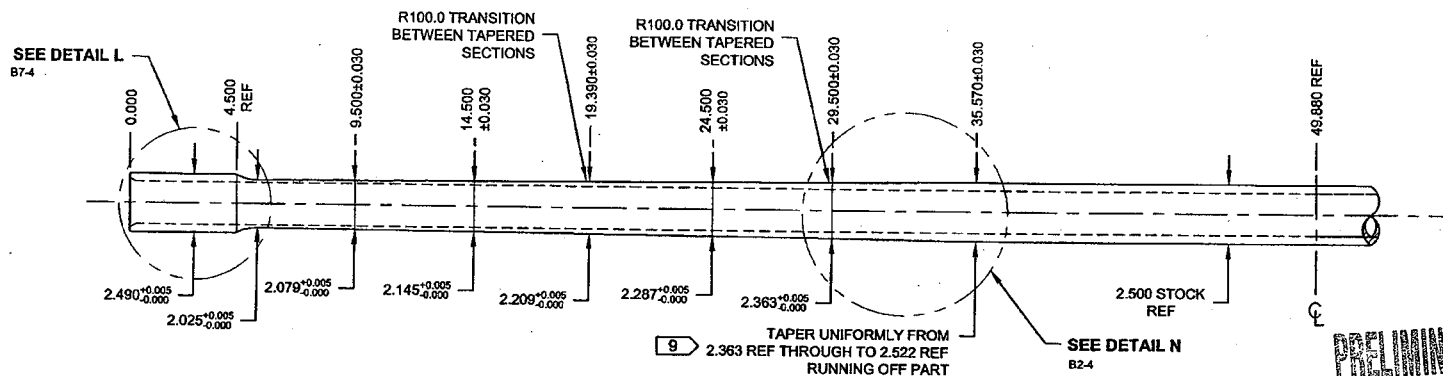


**VIEW C-C:
CUFF DETAIL
SCALE 4X**

DESIGN	99	DART AEROSPACE LTD	
DRAWN	99	HAWKESBURY, ONTARIO, CANADA	
CHECKED	99	DRAWING NO.	REV. 99
MFG. APPR.		D206-667-247	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSS TUBE ASS'Y (206L MID AFT)	NTS
DATE	10.12.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



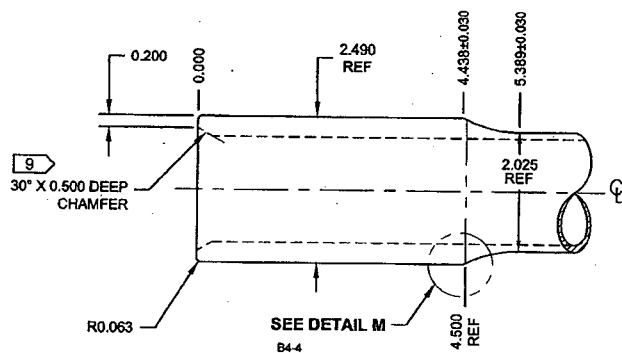
65370



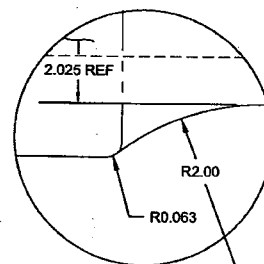
PRELIMINARY ISSUE

Rev PAI 4/11.01.06

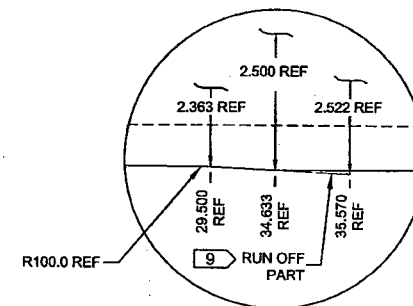
TURNING DETAIL



C7-4 **DETAIL L: CROSSTUBE CUFF**
SCALE 2.5X



B6-4 **DETAIL M: CUFF TRANSITION**
NOT TO SCALE



C4-4 **DETAIL N: TAPER RUN-OFF**
NOT TO SCALE

DESIGN	99	DART AEROSPACE LTD	
DRAWN	99	HAWKESBURY, ONTARIO, CANADA	
CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.		D206-667-247	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (206L MID AFT)	NTS
DATE	10.12.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



LIQUID PENETRANT TEST REPORT

P- 05495

CLIENT DART AEROSPACE DATE JAN 17/2011 PAGE 1 OF 1
ATTENTION LINDA LACELLE / CHANTACE / IAN ACUREN JOB NO. 188-11-2015 TIME AM ☒ PM ☐
ADDRESS 1270, ABERDEN ST. POWO No. 13298
HAWKES BURN, ON WORK LOCATION AS ADDRESS
ACCEPTANCE STD. ASTM1417/CSI-038 REV./DATE 2005
PROJECT F.P.I ON 2 "Cross Tubes"
ITEM(S) EXAMINED SEE BELOW

JOB DESCRIPTION PROCEDURE No. LT002 REV./DATE 2003 TECHNIQUE No. LT-002 REV./DATE 2008
PART No. MATERIAL Alodine Aluminum THICKNESS N/A
SCOPE PERFORMED A WET-FLUORESCENT LIQUID PENETRANT INSPECTION ON 100% OF THE EXTERNAL SURFACE


TEST DETAILS
METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND MAGDA FLUX BLACK LIGHT S/N 13798 ☒ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
PENETRANT 2L-67 MINIMUM DWELL TIME 10 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER A-0 MINIMUM DRY TIME > 10 MIN. OTHER
DEVELOPER SKD-52 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N CAL DUE DATE FEB-05-2011
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- ☐ METRIC ☒ IMPERIAL

1 CROSS-TUBE W.O. ID 65369 ✓
2 CROSS-TUBE W.O. ID 65370 ✓

NO REJECTABLE INDICATION WAS DETECTED
AS PER APPLICABLE STANDARD

"CROSS TUBE"

ITEM ID: - D206-667-107BL
- D206-667-207BL
MM 11-01-18

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES
CLIENT REPRESENTATIVE MATH MURDOCH PRINT SIGNATURE MATH MURDOCH DTR # E-44834
TECHNICIAN (SIGNATURE): YVES DESROSIERS REPORT REVIEWED BY:
NAME (PRINT): YVES DESROSIERS NAME INITIALS
1ST TECHNICIAN CGSB LEVEL 2 SNT LEVEL 2 CGSB REG. No. 3049 2ND TECHNICIAN CGSB LEVEL SNT LEVEL CGSB REG. No.

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY